

DaimlerChrysler AG

Patent claims

1. A method for producing an elongate hollow component (1, 13) comprising a laterally protruding mounting component (14), the mounting component (14) being formed from the hollow component (1, 13), which for this purpose at a point about a horizontal axis (8, 16) intersecting the central longitudinal axis (7, 15) of the hollow component (1, 13) at an angle of approximately 45° is bent upwards or downwards at an angle of approximately 90°, in such a way that the bent section (9, 17) projects laterally in relation to the longitudinal extent of the remainder of the component (1, 13), following which the lateral projection (10, 18) of the bent section (9, 17) is angled at an offset height in relation to the remainder of the component (1, 13) to form the mounting component (14).

2. The method as claimed in claim 1, **characterized in that** the elongate component (1) is produced using two hollow profiles (2, 3) arranged in series, the opposing ends (4, 5) of which are bent upwards or downwards into an equivalent position about the horizontal axis and laterally inverted in relation to an imaginary transverse axis (6) to the central longitudinal axis (7) of the hollow profiles (2, 3), and are then angled in the same direction, the two hollow profiles (2, 3) at their angled ends (4, 5) being joined, preferably welded, to one another to form the hollow component (1).

3. The method as claimed in claim 1, **characterized in that** a partial section (19) of the bent section (17) is bent approximately 90° forwards about a further parallel axis (20) separated by a vertical distance from the horizontal axis (16) - running parallel to the central longitudinal axis (15) of the hollow component (13), and that the partial section (19) is bent further

in a lateral inversion of the preceding bending operations until an end section (24) of the partial section (19) aligns with the unbent remainder of the component (13).

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4. The method as claimed in any one of claims 1 to 3, **characterized in that** the bent section (9, 17) is angled into a horizontal plane.

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5. The method as claimed in any one of claims 1 to 4, **characterized in that** the bent section (9, 17) is flattened in its angled area.

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6. The method as claimed in any one of Claims 1 to 5, **characterized in that** the bent section (9, 17) is perforated in its angled area

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7. The method as claimed in either of claims 5 or 6, **characterized in that** the flattening is bent downwards at a right angle at its edge (11) lying parallel to the hollow component (1, 13).

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8. The method as claimed in claim 1, **characterized in that** after bending the hollow component (1, 13) is expanded in an internal high pressure forming tool by means of a high internal fluid pressure.